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ABSTRACT OF THE DISCLOSURE

A method for attaching a ring electrode to the shaft of the tip section of a catheter comprises passing an electrode lead wire through a lumen in the catheter and out an exit hole in the tip section. The portion of the electrode lead wire extending out of the exit hole is stripped of non-conductive coating and wrapped around the shaft and secured in a clove hitch arrangement. The wrapped electrode lead wire is pulled tight while the material of the shaft is heated to embed the electrode lead wire in the shaft so that its outermost surface is generally flush with the surface of the shaft. The exit hole is sealed and a ring electrode, having a flared skirt is slipped over the shaft to a position over the wrapped electrode lead wire and exit hole. It is then swaged to reduce its outer diameter to about that of the outer diameter of the shaft of the tip section to thereby create a low ohmic connection with the electrode lead wire.

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